

Compliance with EN13236

All diamond blades supplied to OX Group UK must comply with EN13236. We reserve the right to reject any shipment which does not comply with this standard.

We also require that you supply a Certificate of Conformity for every shipment/invoice of goods. Without this invoices will not be passed for payment.

We would particularly like to highlight the following points.

1. Engraving – Product marking
2. Max RPM speeds
3. Cooling hole configuration

1.1 Example Blade Engraving

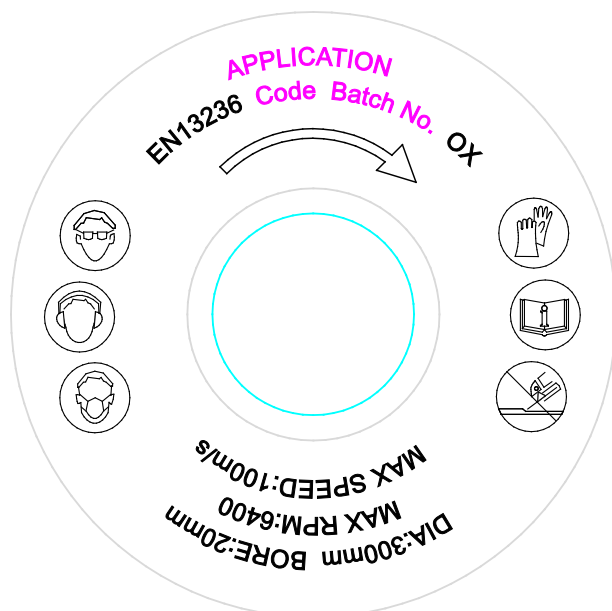


1.2 Engraving Artwork

Application: See table below

Code: Spectrum product code from purchase order

Batch No. Purchase order number



Blade Application Descriptions for Engraving

DX10	Universal/Hard	ZRX	Asphalt/Concrete
DCX	Concrete/GP	USB	Universal
DCA	Abrasive/GP	CG6	Mortar Rake
DA	Asphalt	RD6	Mortar Rake
TX10R	Universal/Hard	RX6	Mortar Rake
MCX	Concrete/GP	RL6	Mortar Rake
MCA	Abrasive/Concrete	RZ6	Mortar Rake
MA	Asphalt	SL	All Tiles
ZX15	Universal/Hard	SM	Ceramics
ZX10	Universal/Hard	SD	Ceramics
ZCX	Concrete	LST	Porcelain
ZCA	Abrasive/Concrete	EM	Marble/GRP
ZA	Asphalt	EMV	Marble/GRP
CGS	General Purpose	LCRV	Concrete/GP
DE10	General Purpose	TK	General Purpose
TC15	Concrete/GP	KDR	Concrete
MC	Concrete-Wet Cut	MKT	Concrete
ZCF	Concrete-Wet Cut	KP	Concrete
RC10	General Purpose		

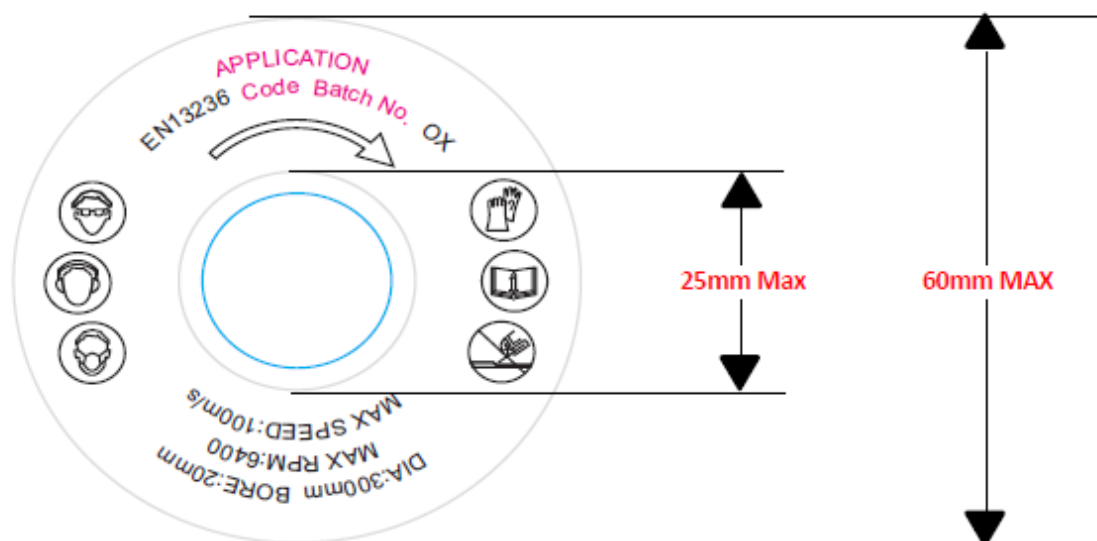
1.3 Engraving Sizes per Blade

Blade Engraving Sizes

Not to Scale

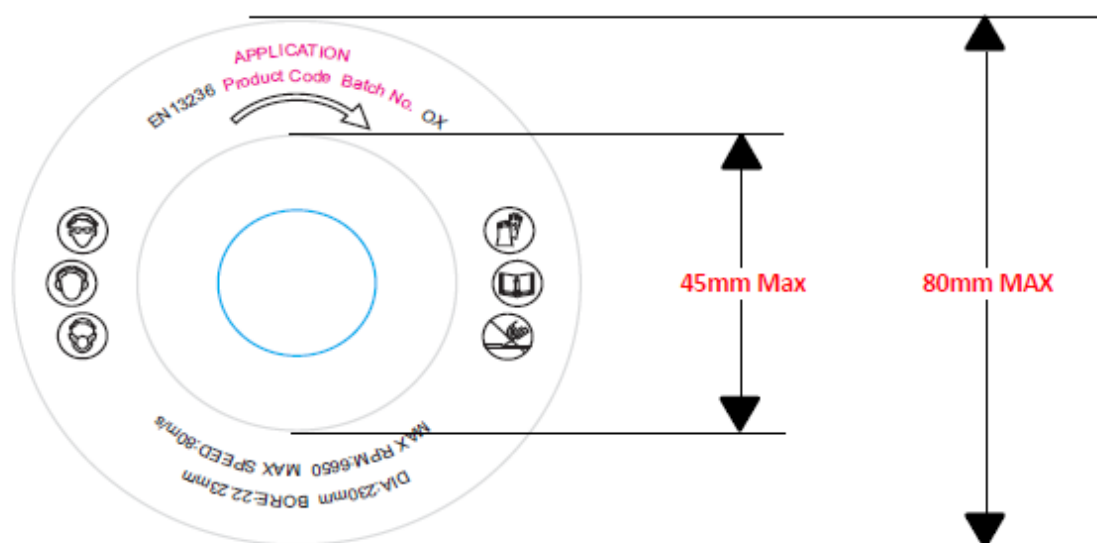
Blade sizes:

80mm, 100mm, 105mm, 110mm, 115mm, 125mm, 150mm, 180mm, 200mm,
250mm, 300mm, 350mm, 400mm, 450mm, 500mm, 600mm, 700mm, 900mm



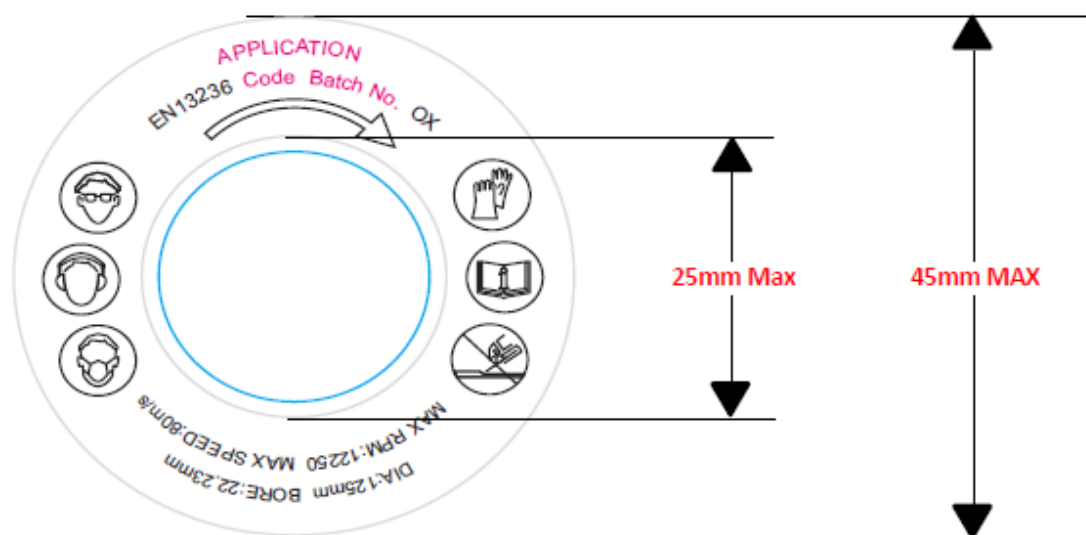
Blade sizes:

230mm

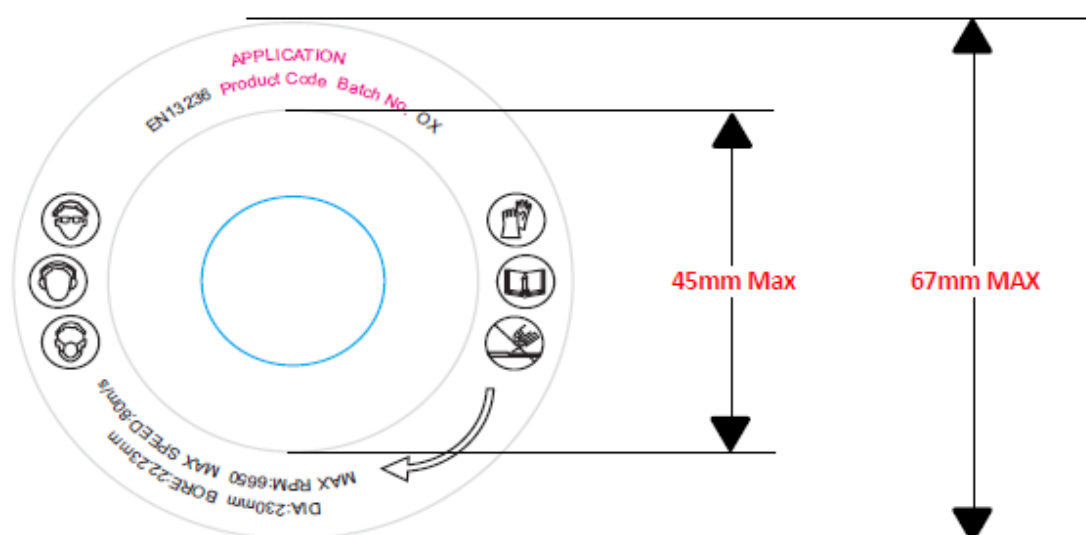


Blade Engraving Sizes for blades with re-enforced centre flange**Not to Scale****Blade sizes:**

105mm, 115mm, 125mm, 150mm,

**Blade sizes:**

180mm, 200mm, 230mm, 250mm



2.1 **Max RPM Speeds**

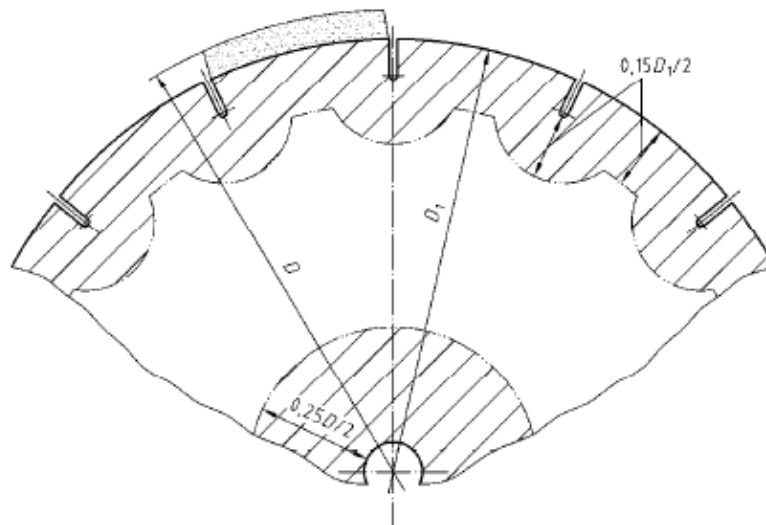
Max RPM speeds for laser and sintered blades

Blade Diameter	m/s	RPM
100/105mm	80m/s	14500
110/115mm	80m/s	13200
125mm	80m/s	12000
150mm	80m/s	10200
180mm	80m/s	8500
200mm	80m/s	7600
230mm	80m/s	6600
250mm	80m/s	6100
300mm	100m/s	6400
350mm	100m/s	5400
400mm	100m/s	4800
450mm	80m/s	3400
500mm	80m/s	3000
600mm	80m/s	2500

****300mm, 350mm and 400mm blades must be rated to 100m/s as all the machines these blades are used on run faster than 80m/s.****



3.1 Cooling Hole Configuration



Key



No cuts allowed in this area

Figure 1 — Position of cuts and openings in steel blanks

5.3.5.3.2 Dimensions and distribution of narrow laser cuts

- a) Cuts outside the flange area shall have a maximum radial dimension of $\leq 40\%$ of the blank radius $D_1/2$.
- b) The minimum distance between cuts outside the flange area at any point of the cut-out shall be $\geq 15\%$ of the radius of the cutting-off wheel $D/2$.
- c) Laser cuts shall start and end with a spiral.

5.3.5.3.3 Dimensions and distribution of wide cut-outs and openings

- a) Wide cut-outs and openings in blanks shall have radial dimension of $\leq 15\%$ of the radius of the cutting-off wheel $D/2$ with an opening angle of 15° at maximum, see Figure 2 as an example

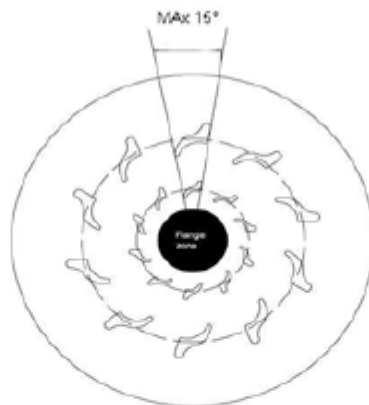


Figure 2 — Example of cut-outs and openings

- b) The total area of wide cut-outs and openings in blanks shall be $\leq 20\%$ of the area of the blank.

5.3.5.4 Heat treatment of all metal blanks

If slots or openings are produced by laser cutting, the steel blank shall be annealed if the micro hardness is > 500 HV in the heat affected zone, in order to achieve a hardness of ≤ 500 HV.